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Thomas [SE/SE]; Parkvägen 43, S-737 31 Fagersta (SE). JONSSON, Mats [SE/SE]; Brunna 10, S-776 12 Hedemora (SE).

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(74) Agent: CARLSSON, Lars-Åke; Sandvik AB, Intellectual Property, S-811 81 Sandviken (SE).

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(71) Applicant (*for all designated States except US*): SECO
TOOLS AB [SE/SE]; S-737 82 Fagersta (SE).

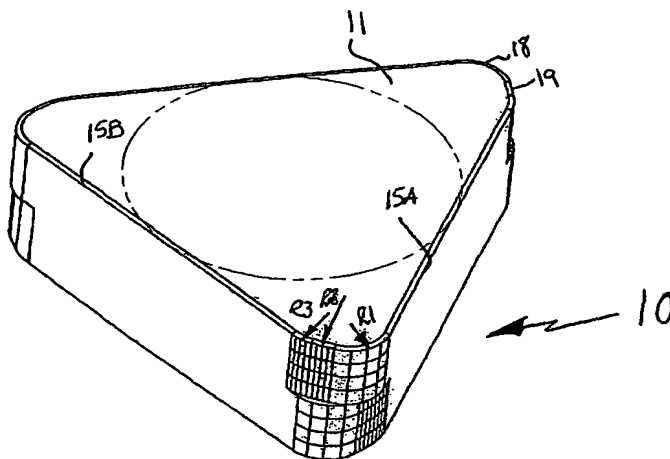
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(72) Inventors; and

(75) Inventors/Applicants (*for US only*): NORSTRÖM,

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(54) Title: CUTTING INSERT AND METHOD



(57) Abstract: The present invention relates to an indexable insert for chip removing machining. The cutting insert (10) has a negative, polygonal basic shape and comprises cutting corners (17). Each cutting corner comprises a nose edge (18) and a minor cutting edge (19; 19'). The nose edge connects to a major cutting edge (15A, 15B) and to the minor cutting edge. A bisector (B) of the corner intersects the nose edge. Upper cutting edges (15A, 15B) are formed in transitions between a top side (11) and an edge surface (13) of the cutting insert. Lower cutting edges are formed in transitions between a bottom side (12) and the edge surface (13). Said sides (11, 12) constitute a rake face in one position and a support surface in another position and said edge surface (13) constitutes an edge surface. Each cutting corner (17) is asymmetrical in relation to the bisector (B) of the corner. The nose edge (18) is defined by a radius (R1) that is smaller than a radius (R2) of the minor cutting edge. Each side (11, 12) comprises a plurality of nose edges (18), which at least partly touch a plane (P). An imaginary line (L), which is perpendicular to the plane (P) and tangent to the minor cutting edge (19), intersects the edge surface (13). The minor cutting edge (19) is curved. The invention also relates to a method for manufacturing a cutting insert for chip removing machining.

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